

# Work Order ID 54530

December 10, 2009 3:46:56 PM



Page 1

Item ID: D3049-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 10/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*Handwritten signature*

Date:

*12-10*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3049

Rev A1

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1  
3-Deburr

*Handwritten notes: DTP 09/12/18 MMJ 09/12/20*

*8*

*2*

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Handwritten notes: MMJ 09/12/20*

*8*

*2*

140

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Handwritten notes: H.A 09/12/21*

*8*

*2*

*Handwritten circled 8*

*Handwritten notes: 9-12-16*

*Handwritten note: waterjet*

*Handwritten note: 100*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54530**

December 10, 2009 3:46:56 PM



Page 2

Item ID: D3049-1

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Setup Start



Revision ID:

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Item Name: Bearpaw

Start Date: 10/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*PRD*  
*54488*  
*09/12/22* (8)

*09/12/22* *[Signature]*

*CL09/12/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

December 10, 2009 3:47:00 PM

Page 1

Work Order ID: 54530

Parent Item: D3049-1

Parent Item Name: Bearpaw

Start Date: 10/12/2009

Required Date: 18/12/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Pen Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MUHMWB10		Purchased	No			120	sf	383.3041	27.2000			
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UHMW 1" Black



B 9-12-16

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	341.2164	
112186	122.0164	
112514	11.2	
113166	208	
Main Warehouse		
ST	42.0877	
111354	42.0877	

113166

8

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	54530
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D3049-1
<b>Inspection Dwg:</b> D3049 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0.260	✓			
B	0.93	+/-0.030	0.923	✓			
C	0.40	+0.030/-0.000	0.405	✓			
D	2.00	+/-0.030	2.00	✓			
E	10.250	+/-0.010	10.250	✓			
F	4.540	+/-0.030	4.540	✓			
G	5.88	+/-0.030	5.88	✓			
H	0.38	+/-0.030	0.38	✓			
I	11.50	+/-0.030	11.50	✓			
J	0.07 x 45°	+0.030/-0.010	0.07 x 45°	✓			
K	0.44 - 0.47	+/-0.000	0.462	✓			
L	R0.25	+/-0.030	0.25	✓			
M	0.38	+/-0.010	0.376	✓			
N	0.95	+0.030/-0.010	0.980	✓			
O	0.69	+/-0.030	0.69	✓			
P	0.20	+/-0.030	0.20	✓			
Q	23.00	+/-0.030	23.00	✓			
R	0.25 x 45°	+/-0.030	0.25 x 45°	✓			

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>G.A.</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/12/19	<b>Date:</b>	09/12/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

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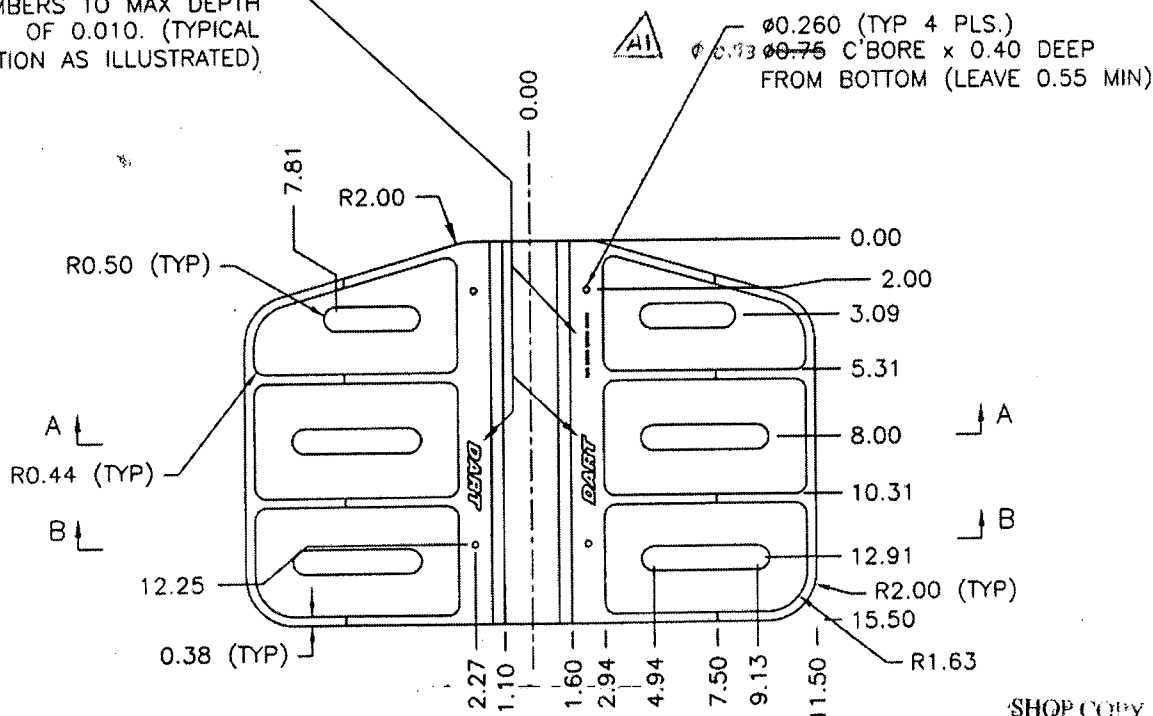
**DART**



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18	TITLE BEARPAW	SCALE 1:7	
A	01.10.18	NEW ISSUE	
AI	03.01.13	Ø0.93 to 45 Ø0.75	

RELEASED  
01.10.24

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54530  
PB 09-2-10

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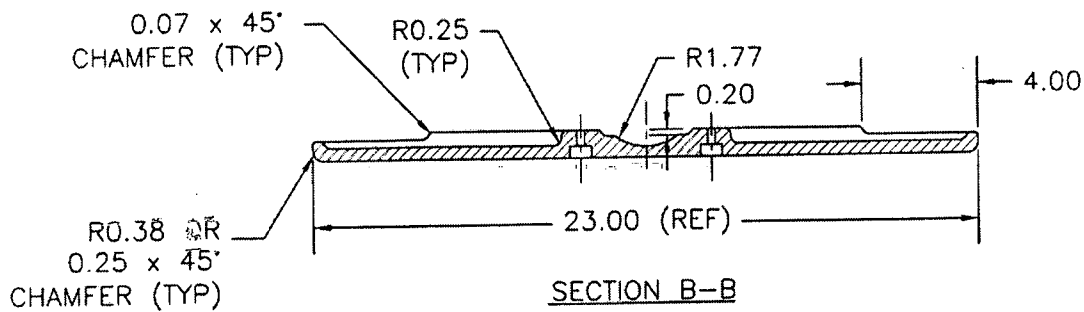
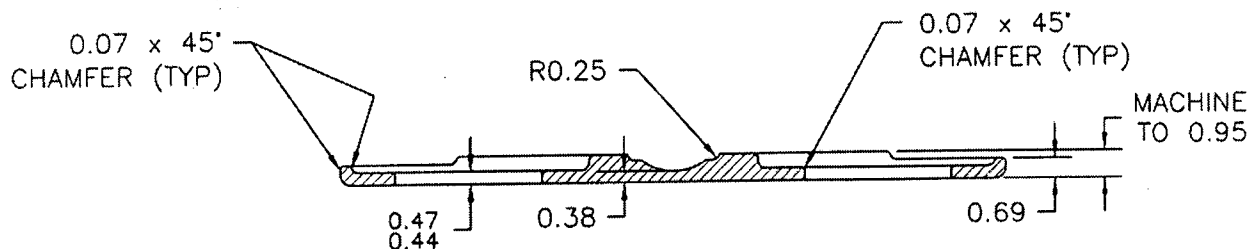
**NOTE:** Date & initial all entries



W/054538

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
01.10.24 H



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